

Work Order ID 80493

80493

Page 1

February-21-12 3:10:24 PM

Item ID: D4543-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Outer, LH

Start Date: 21/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 12/02/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4543

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut as per dwg

Prog rev: A

Dwg rev: A

2- Deburr

B12-3-5

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-3-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Small Fab

Memo

0.00

Small Fab

FORM ON BEAD ROLLER (DT9787)

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

8/7/03/05

(X3)

(3)

FF 12-03-12

8/7/03/12

(Y3)

-1

Dart Aerospace Ltd

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Page 3

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Retainer, Outer, LH

Stop

NS2

Start Date: 21/02/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

3X0 M/12/03/12

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

3 BR 12-3-12

170

Identify as per dwg & Stock Location 8151

0.00

170

Packaging

Memo

0.00

Packaging

3x SP 12-03-12

180

QC21 - Final Inspection. W/O Release

12/3/13 DJ
12-03-13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

February-21-12 3:10:28 PM

Page 1

Work Order ID: 80493

80493

Parent Item: D4543-1

D4543-1

Parent Item Name: Retainer, Outer, LH

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	212.3860	0.611	1.286316	2,		

M6061T6S 032

6061-T6 Sheet 0.032"

**

B12-3-5

Location

Loc Qty

Loc Code

MAT021

212.386

118106

54.106

120218

73.1

120285

85.18

120218

3

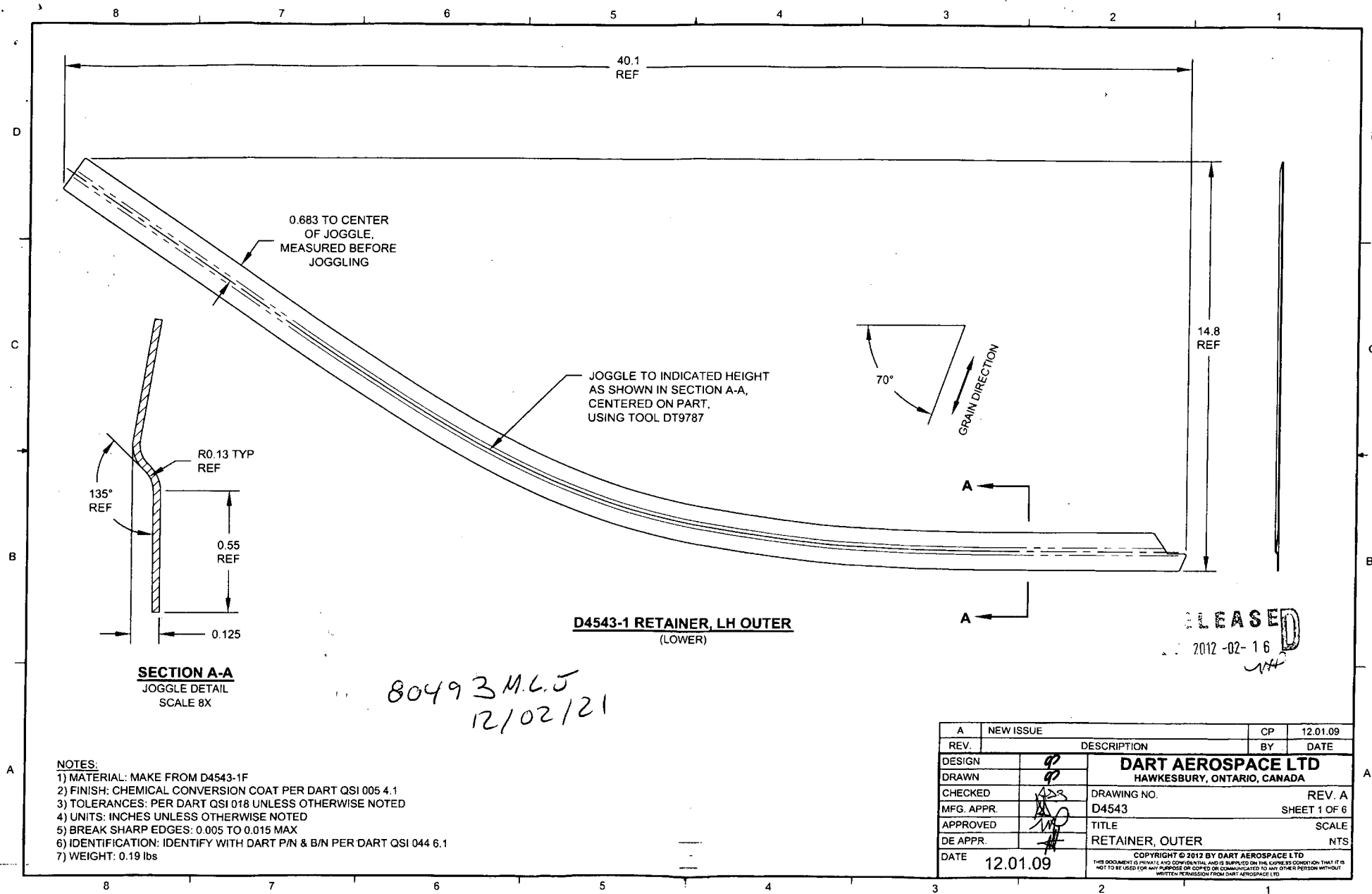
W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: MAKE FROM D4543-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.19 lbs

A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	q		
DRAWN	q		
CHECKED	123		
MFG. APPR.	W		
APPROVED	W		
DE APPR.	W		
DATE	12.01.09		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWING NO. D4543		SHEET 1 OF 6	
TITLE RETAINER, OUTER		SCALE NTS	
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Dart Aerospace Ltd

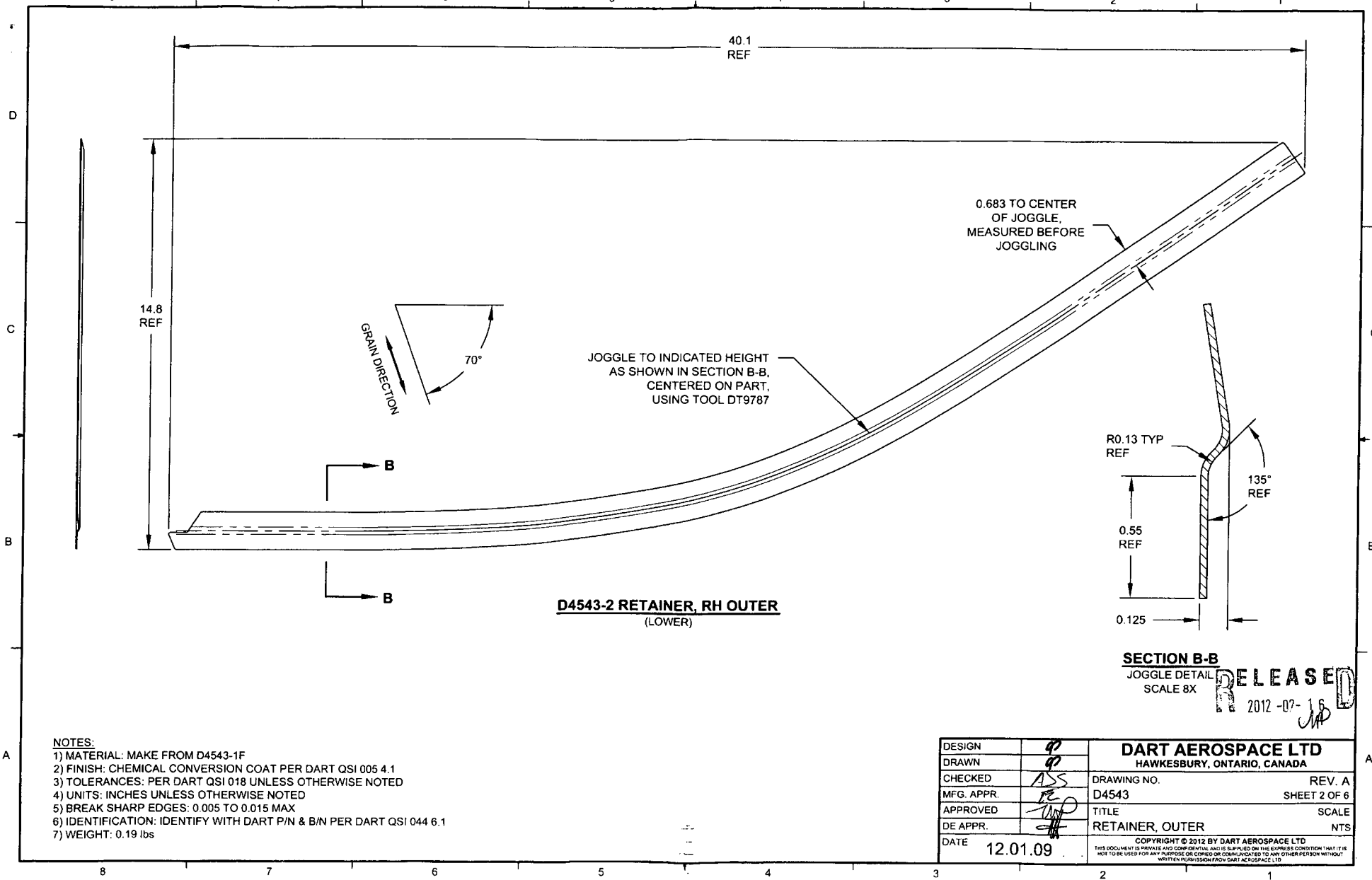
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

80493



- NOTES:**
- 1) MATERIAL: MAKE FROM D4543-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 0.19 lbs

DESIGN	<i>Q</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>Q</i>		
CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>FE</i>	D4543	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER, OUTER	NTS
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RELEASED
2012-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

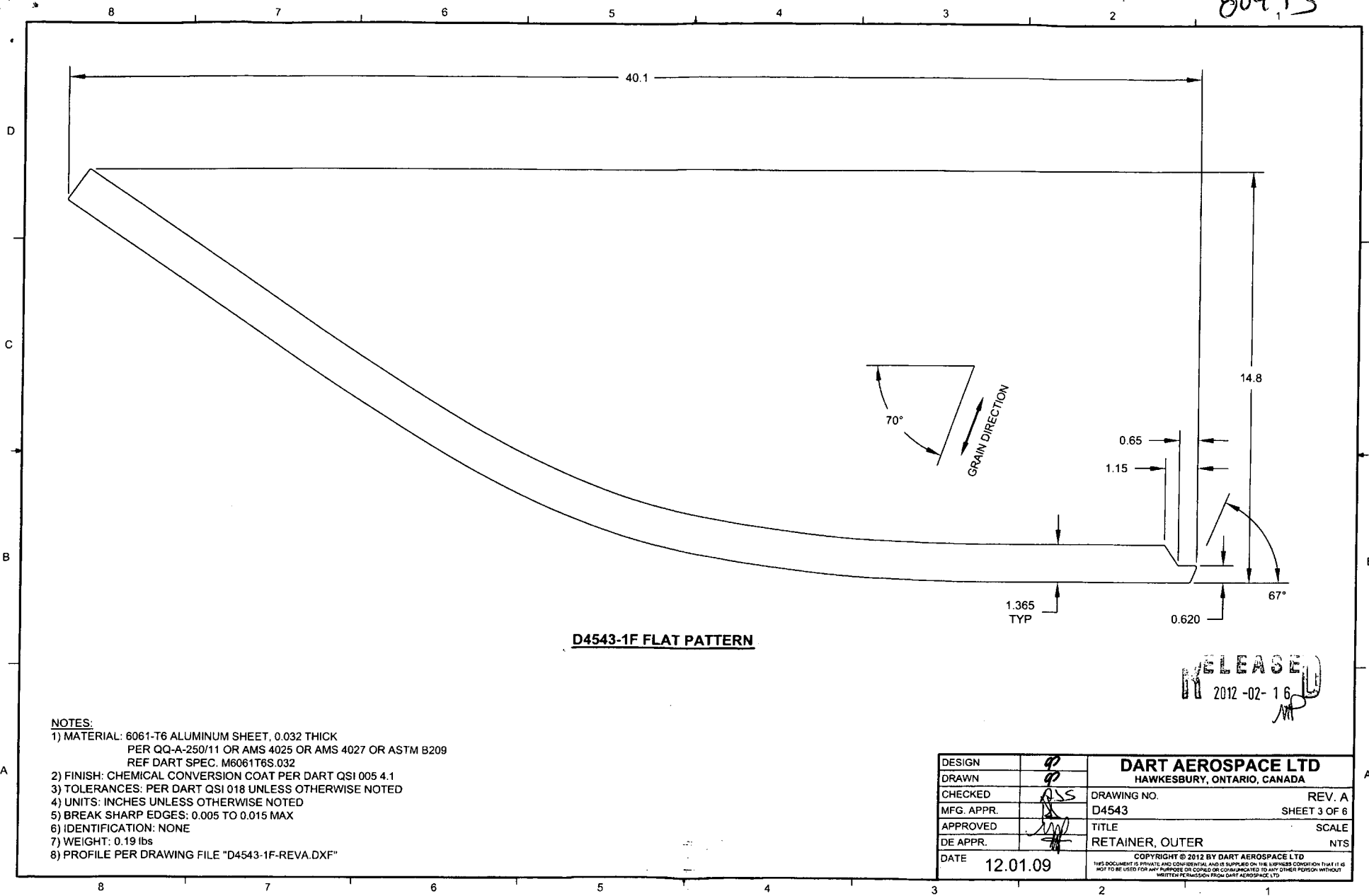
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80493



D4543-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs
- 8) PROFILE PER DRAWING FILE "D4543-1F-REVA.DXF"

DESIGN	<i>Q</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>Q</i>		
CHECKED	<i>QSS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4543	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RETAINER, OUTER	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

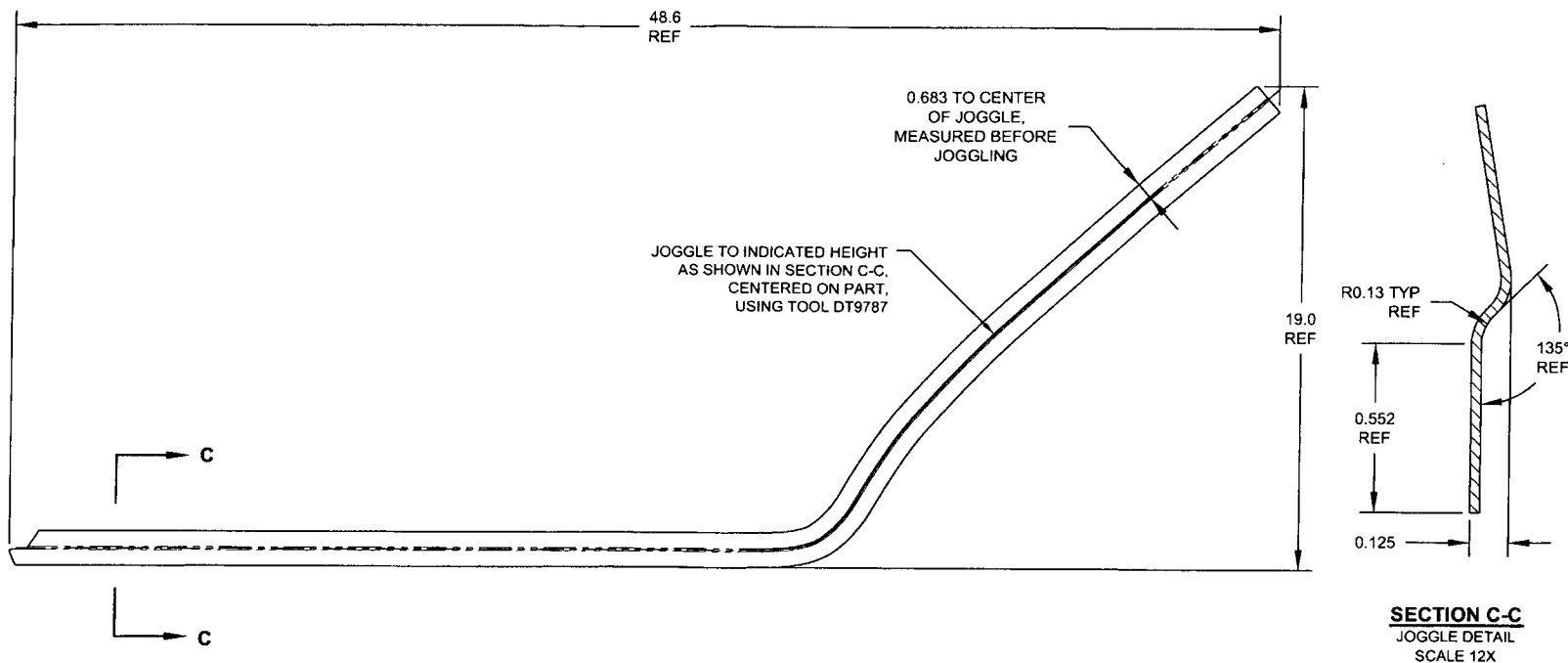
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

80493



D4543-3 RETAINER, LH OUTER
(SIDE/TOP)

SECTION C-C
JOGGLE DETAIL
SCALE 12X

RELEASED
2012-02-16

NOTES:

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	<i>DP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DP</i>		
CHECKED	<i>SS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4543	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

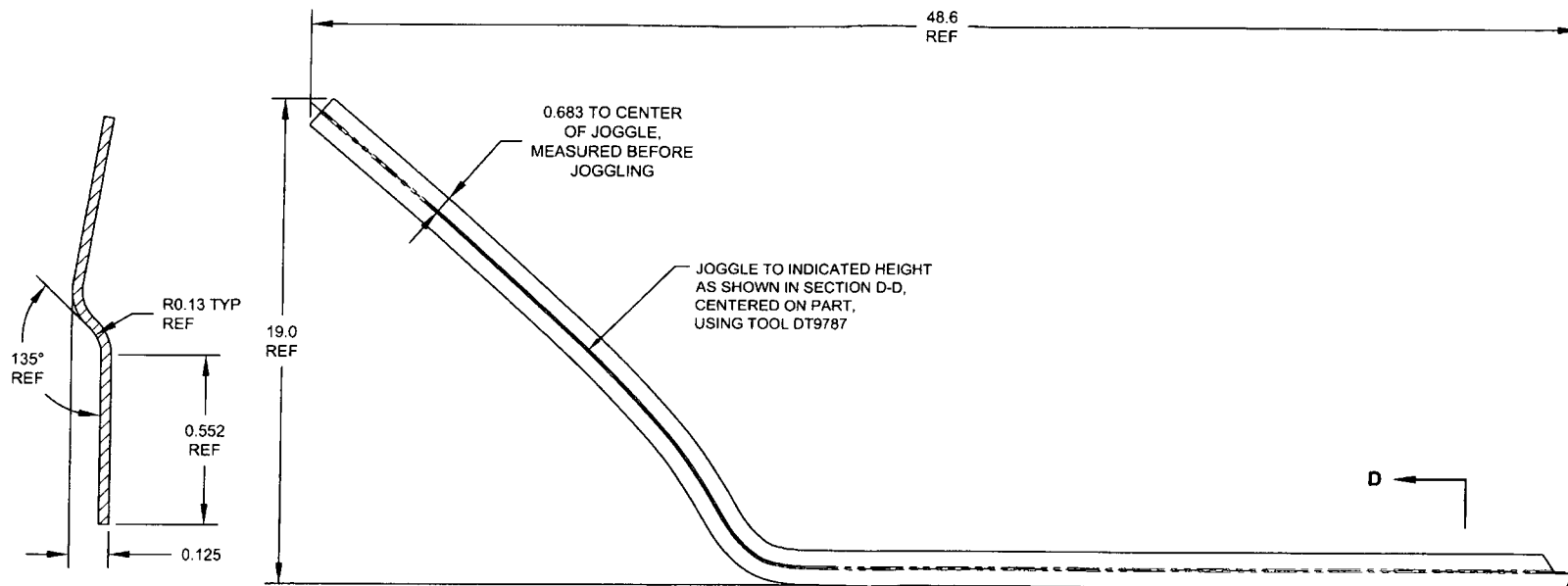
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80493



SECTION D-D
JOGGLE DETAIL
SCALE 12X

D4543-4 RETAINER, RH OUTER
(SIDE/TOP)

RELEASED
2012-02-16

NOTES:

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 5 OF 6
APPROVED		TITLE	SCALE
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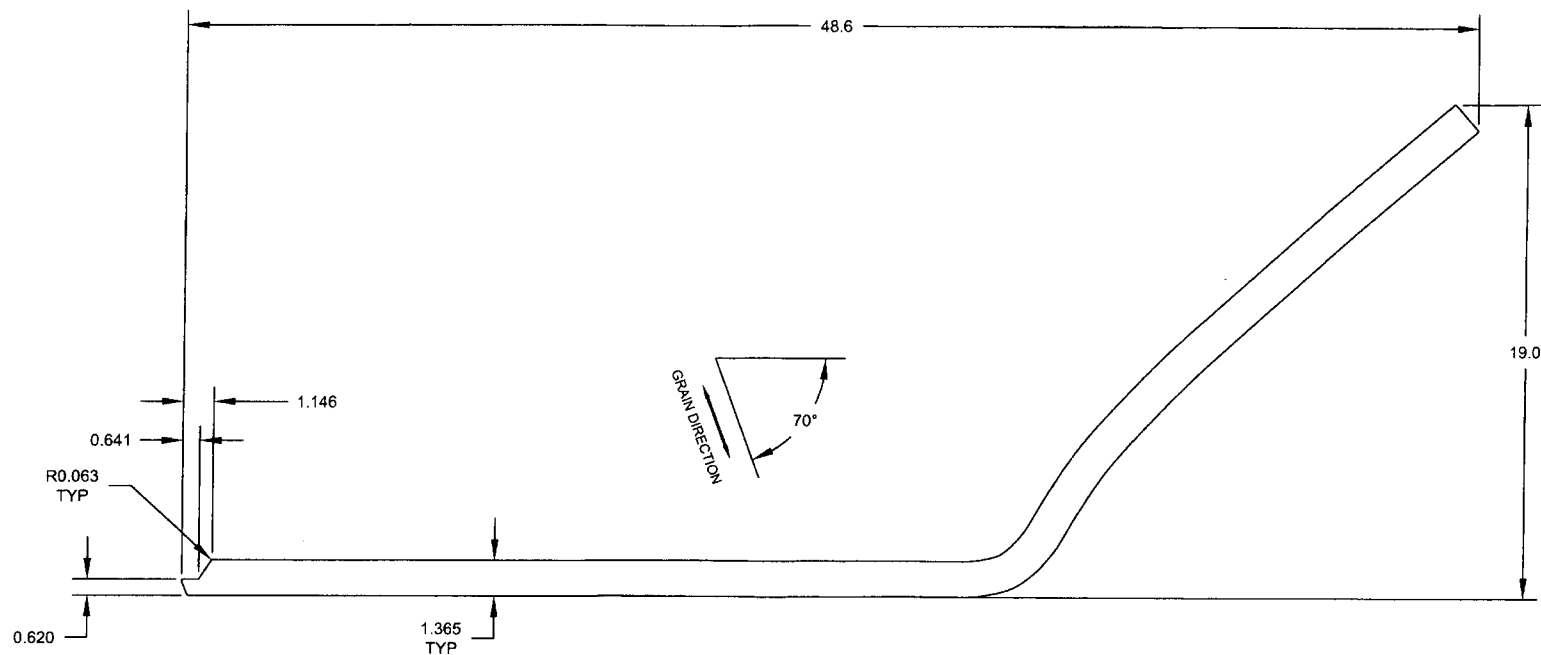
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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVA.DXF"

RELEASED

2012-02-16

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DRAWN	92		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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